

Work Order ID 60623

Thursday, July 15, 2010 10:28:10 AM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop



Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *P*

Date: *10-7-15* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3913

A

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *M113323* 0.00
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
inspect before welding mesh
2- tack weld mesh on basket as per dwg D3913 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

110



QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds 0.00

Memo

0.00

10/07/22 *(W)*

Plc 10.07.22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 10/07/26

Memo

0.00



125



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

1 BL 10-7-26

W/O:		WORK ORDER CHANGES						
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[illegible]

Page 3

Accept

**Setup Start**

Stop

Cust Item ID:[illegible]

Customer:

Reference:

Run Start

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

**Insp.
Stamp**

0.00

[illegible]

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*****2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

[illegible]

QC

Quality Control

Memo

0.00

① - 16k 10-7-20

• 5/10/07/27 (D)

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Item ID: D3913-041

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Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



HandFinish

Assemble as per dwg

0.00

Memo

0.00

Hand Finishing

Pick Kit

EB10/07/27 @

160



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

EB10/07/27

@

170



Packaging

Identify as per dwg & Stock Location

6-A

0.00

Memo

w/o B60620

0.00

Packaging

EB10/07/27 @

W/O:		WORK ORDER CHANGES						
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Revision ID:					Stop	
Item Name:	Long Basket Base Assembly, 350					
Start Date:	7/15/2010	Start Qty:	1.00			
Required Date:	7/22/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/07/28 

U1207.27

W/O:		WORK ORDER CHANGES						
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Picklist Print

Thursday, July 15, 2010 10:28:16 AM

Page 1

Work Order ID: 60623

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/15/2010


Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	----------------	--------------	---------------	----------------	--------

D2581  Mounting Bracket		Manufactured	No			100	Each	13.0000	2	2		10/07/21	
--	--	--------------	----	--	--	-----	------	---------	---	---	--	----------	--


Location Loc Qty Loc Code

WA	13	
46086	2	
51745	1	
57185	1	
* 59265	9	

✓ D3913-1  Rib		Manufactured	No			100	Each	4.0000	1	1		10/07/21	
---	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location Loc Qty Loc Code

WA	4	
59337	1	
59842	3	

✓ D3913-15  Wide Handle Plate		Manufactured	No			100	Each	6.0000	1	1		10/07/21	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location Loc Qty Loc Code

WA	6	
58586	3	
60324	3	

W/O:		WORK ORDER CHANGES						
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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-3 Manufactured No 100 Each 5.0000

 Rib

Location

Loc Qty

Loc Code

WA


5

59338

2

60323

3

✓ D3913-7 Manufactured No 100 Each 11.0000

 Rib

Location

Loc Qty

Loc Code

WA

11

59339


2

59743

3

60263

6

✓ D3913-9 Manufactured No 100 Each 5.0000

 Hinge Rib

Location

Loc Qty

Loc Code

WA


5

59731

2

60322

3

✓ D3916-041 Manufactured No 100 Each 4.0000

 Rib Assembly

Location

Loc Qty

Loc Code

WA

4

59732

4



1 1
 10/07/21



2 2
 10/07/21



1 1
 10/07/21



2 2
 B60046 ② 10/07/21

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Page 2

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Page 3

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3916-5	Manufactured	No	100	Each	9.0000	3	3	
Light Rib								
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
		WA		9				
		57023		2				
		59535		7				
								B60321 @ 10/07/21
✓ D4016-1	Manufactured	No	100	Each	9.0000	3	3	
Hinge Half, Base								
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
		WA		9				
		59983		9				
								10/07/21
J D4017-7	Manufactured	No	100	Each	8.0000	1	1	
Rib								
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
		WA		8				
		58929		2				
		59836		3				
		60473		3				
								10/07/21
✓ D4017-9	Manufactured	No	100	Each	10.0000	2	2	
Rib								
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
		WA		10				
		59538		4				
		59984		6				
								10/07/21

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Page 3

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Page 4

Work Order ID: 60623

Parent Item: D3913-041


Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D4020-1

 Mesh (350 Basket Long, Base)

Manufactured No

100 Each

4.0000

1

1



Handwritten: 10/07/22

Location

Loc Qty

Loc Code

WA


4

59555

1

59848

3

✓ D4020-11

 End Mesh, Basket

Manufactured No

100 Each

10.0000

2

2



Handwritten: B60584 ① 10/07/22

Location

Loc Qty

Loc Code

WA

10

58136


1

59413

5

59942

4

✓ D4021-1

 Handle Plate

Manufactured No

100 Each

18.0000

3

3



Handwritten: 10/07/21

Location

Loc Qty

Loc Code

ST109

5

57086

5

WA


13

59746

4

60183

9

✓ D4034-041

 Aft Upper Rib Assembly

Manufactured No

100 Each

3.0000

1

1



Handwritten: 10/07/21

Location

Loc Qty

Loc Code

WA

3

58729

1

59747

2

Handwritten: ①

Thursday, July 15, 2010 10:28:16 AM

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Page 4

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Page 5

Work Order ID: 60623

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D4034-043 Manufactured No 100 Each 3.0000



Fwd Upper Rib Assembly

3.0000



1

1

10/07/21

Location

Loc Qty

Loc Code

WA

3

59748

3

AN3-10A

Purchased No



Bolt

150 Each 85.0000

85.0000



6

6

10/07/27

Location

Loc Qty

Loc Code

ST351

85

115016

85

AN960JD8

NAS1149DN832

Purchased No



Washer

D2931



Bumper

150 Each 0.0000

0.0000



2

2

10/07/27

Manufactured No

150 Each 816.0000

816.0000



2

2

10/07/27

Location

Loc Qty

Loc Code

ST504

816

46064

816

D4021-5

Manufactured No



Blanking Plate

150 Each 3.0000

3.0000



2

2

10/07/27

Location

Loc Qty

Loc Code

ST111

3

59096

3

2

360717 (2x)

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Page 6

Work Order ID: 60623

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

MS20600-AD4W3 Purchased

No

150

Each

1,631.000

2



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1631

106375

3

107939

822

111636

806

Start Date: 7/15/2010 Required Date: 7/22/2010
Start Qty: 1.00 Required Qty: 1.00
2
7/10/07/27

MS21042L3 Purchased

No

150

Each

2,684.000

6



Nut

Location

Loc Qty

Loc Code

ST300

2684

112385

4

114523

204

114718

476

114784

2000

2
6
7/10/07/27

NAS1149F0332P Purchased

No

150

Each

691.0000

12

12



WASHER

Location

Loc Qty

Loc Code

ST275

691

18057

691

12
7/10/07/27

12

Thursday, July 15, 2010 10:28:16 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

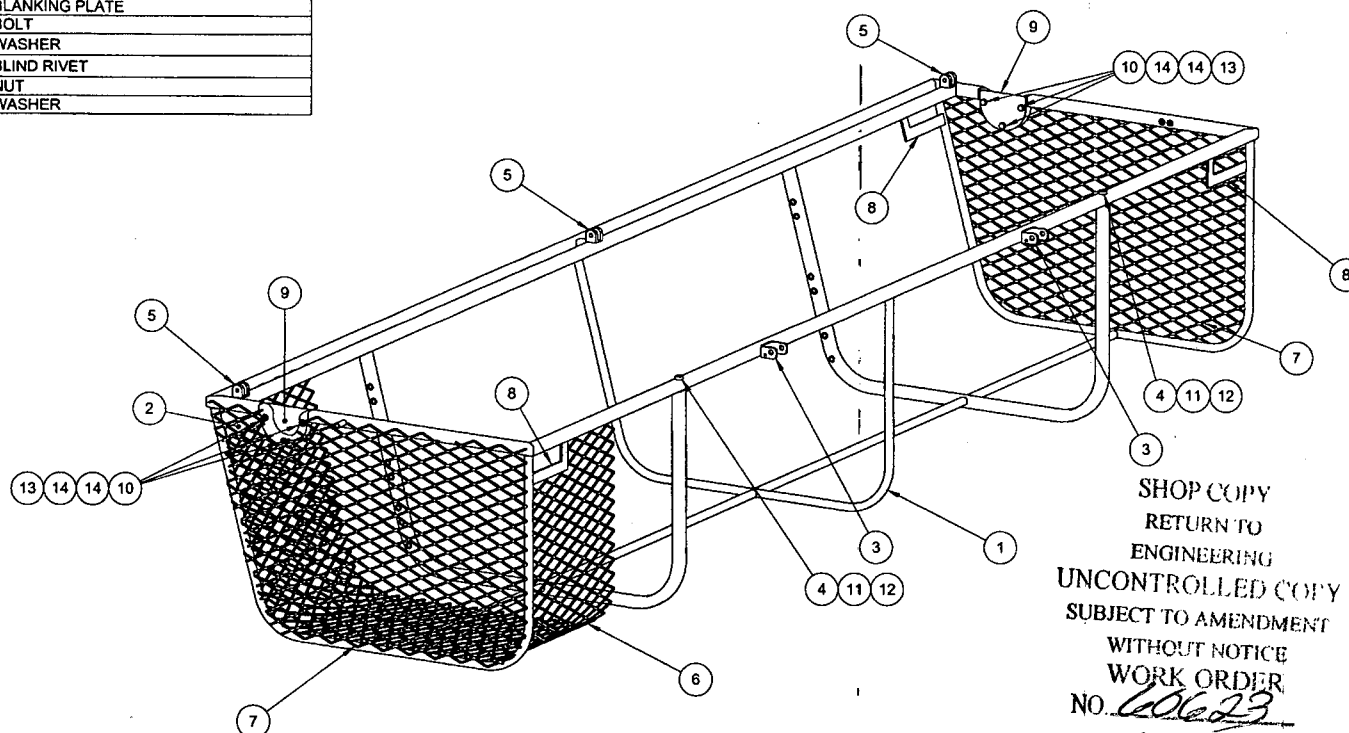
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60623

RELEASED
2010-03-22
JWP

NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JFH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3913	REV. A
TITLE LONG BASKET BASE ASSY (350) NTS	SHEET 1 OF 6
SCALE	
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2

D A7-3
D8-2
D4020-1
MESH

D3913-101
TUBULAR ASSY

D2931 BUMPER
AN980JD8 WASHER
MS20600AD4W3 RIVET
2 PL 8

D2581
MOUNTING BRACKET
2 PL

D4016-1
HINGE HALF, BASE
3 PL

0.75
D4021-1
HANDLE PLATE

D4021-1
HANDLE PLATE
2 PL

D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	_____	DRAWING NO.	REV. A
MFG. APPR.	_____	D3913	SHEET 2 OF 6
APPROVED	_____	TITLE	SCALE
DE APPR.	_____	LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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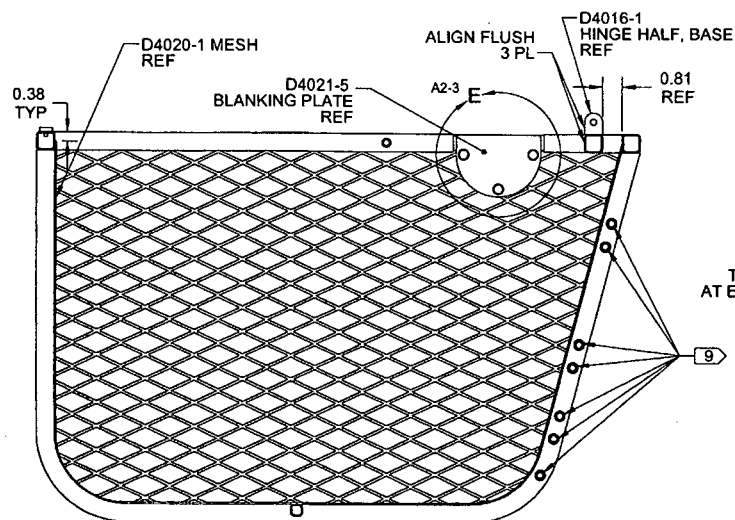
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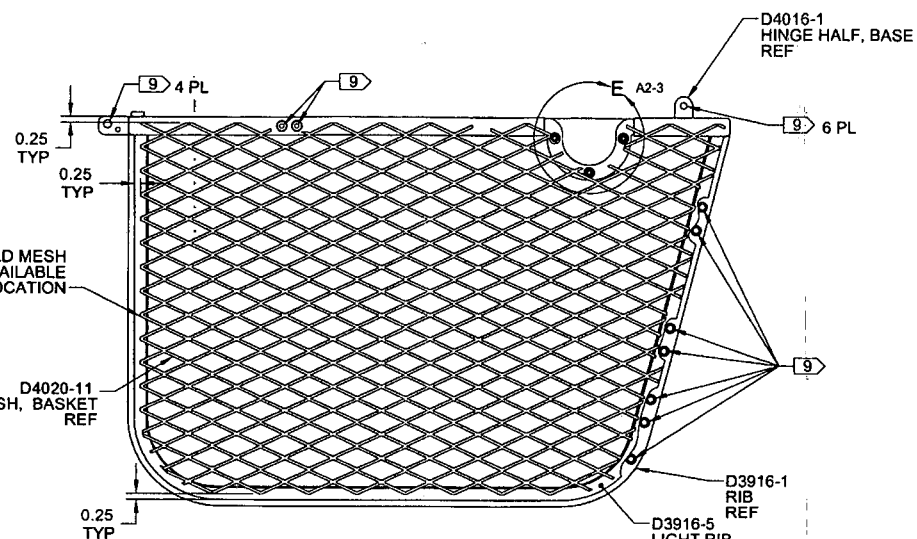
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

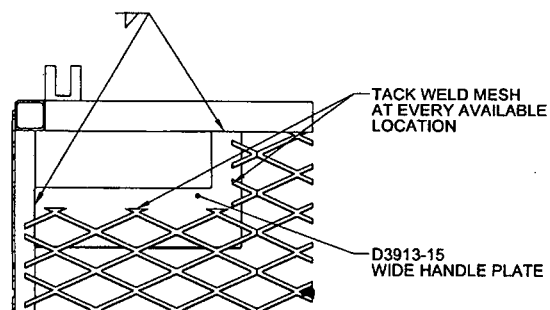
NOTE: Date & initial all entries



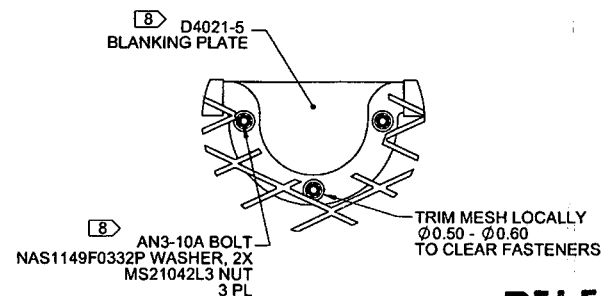
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D8-3

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

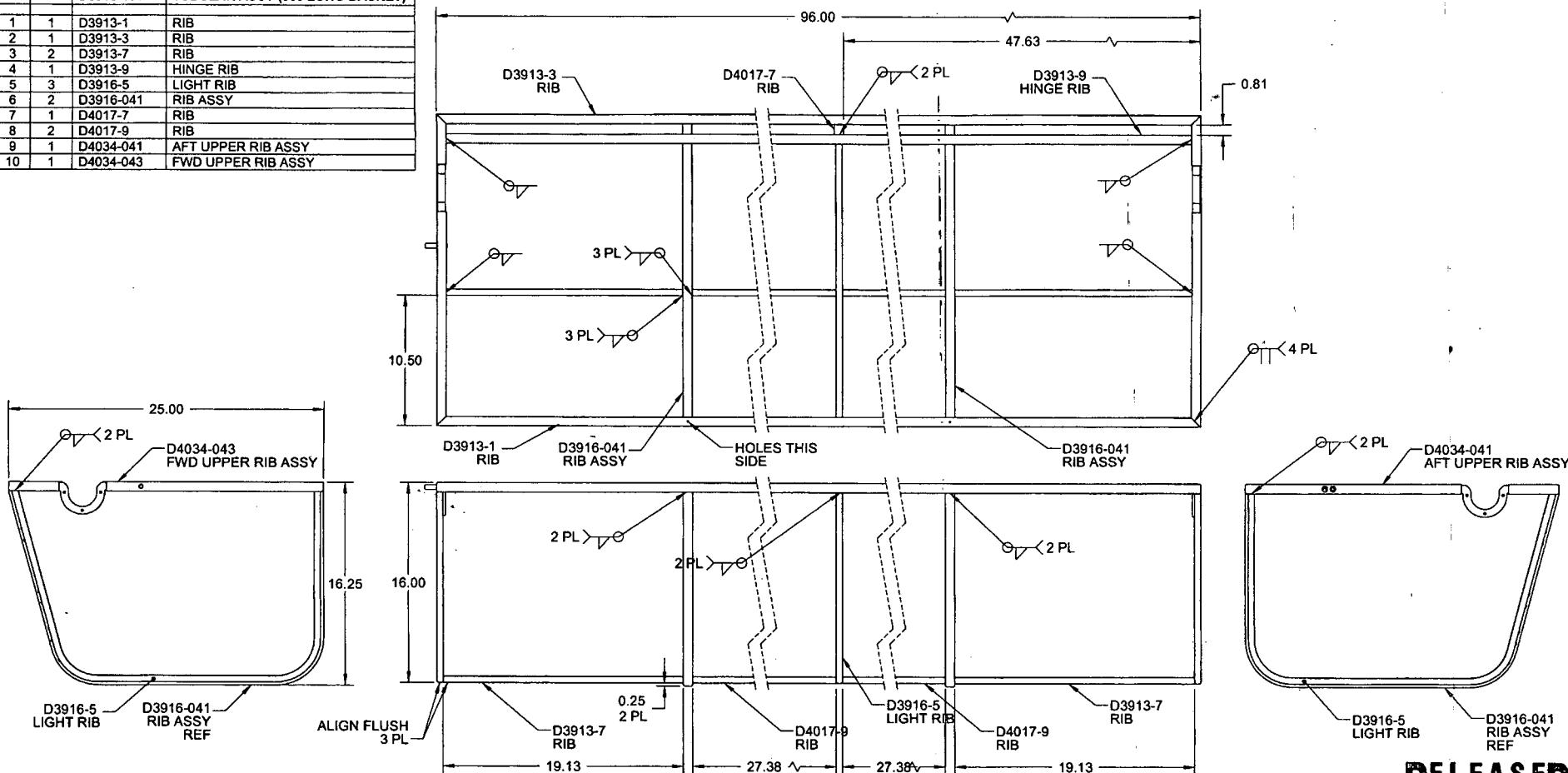
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 22.53 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
 - 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3913 TITLE LONG BASKET BASE ASSY (350) SCALE NTS
DRAWN	JPH	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.03.16	REV. A SHEET 4 OF 8 COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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2010-03-22

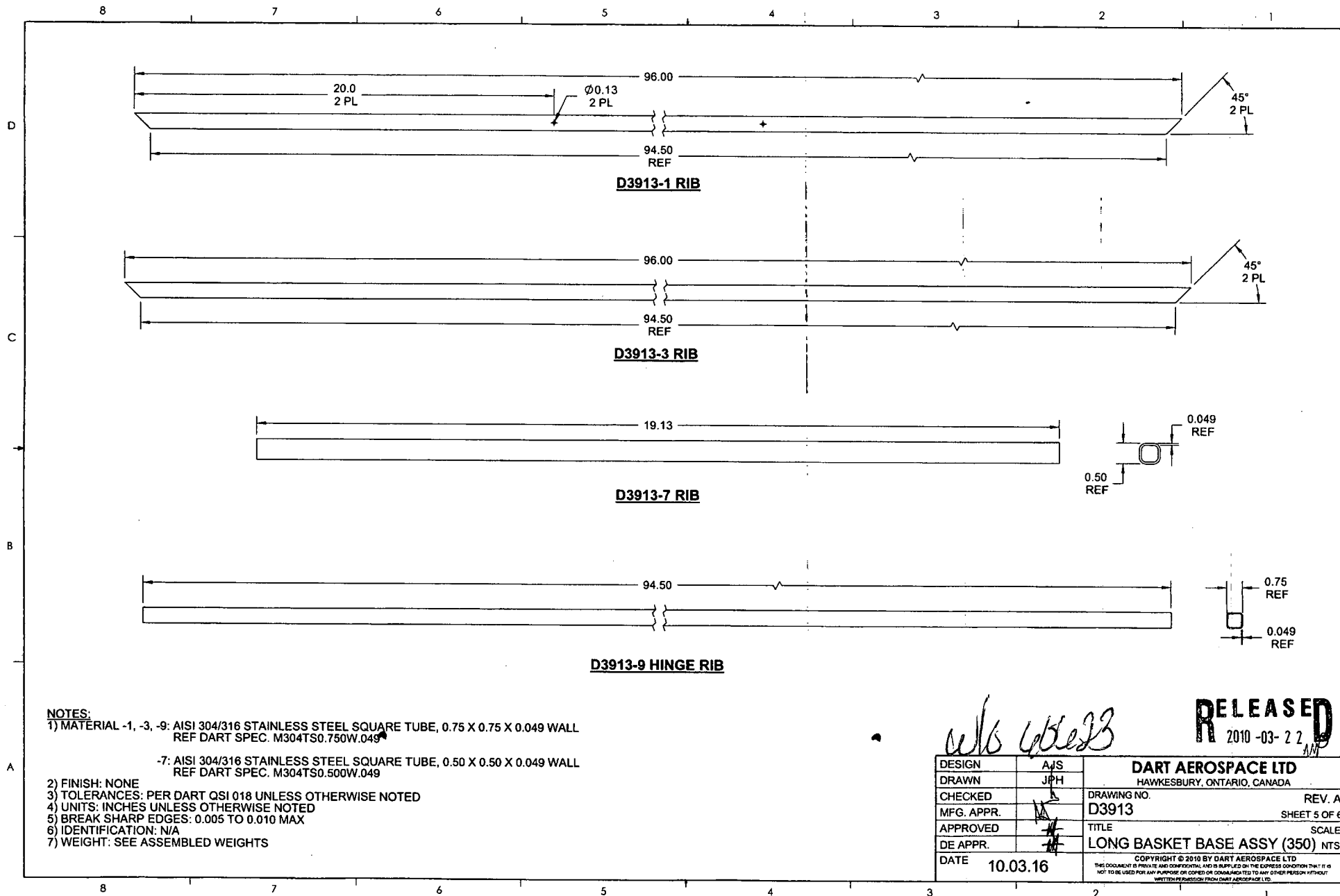
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



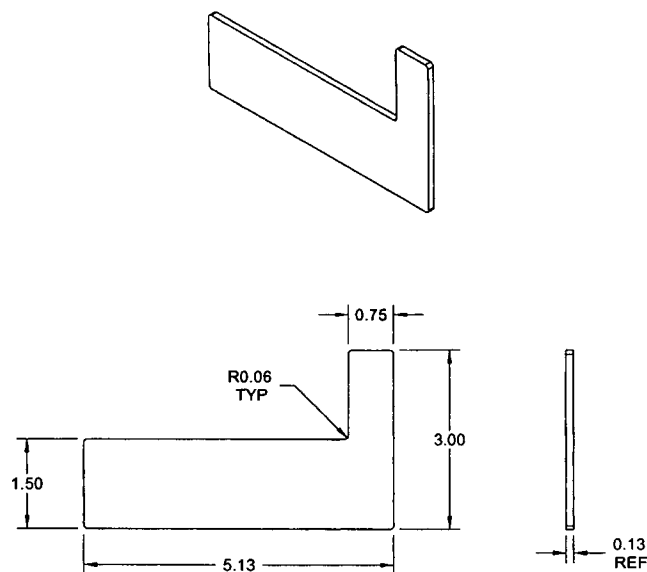
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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2010-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries